

Date: Wednesday, 3/26/2008 10:02:16 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FITTING
 Job Number : 38192
 Estimate Number : 11160
 P.O. Number :
 This Issue : 3/26/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D32571
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3257 REV A1
 Previous Run : 32827 Material :
 Due Date : 4/5/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : SD 08-3-27
 Comment : Est: A 04.04.14 New issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M303B0500X0500 AISI 303 Bar .5 x .5



Comment: Qty.: 0.1147 f(s)/Unit Total: 0.6880 f(s)

AISI 303 Bar .5 x .5

Material: AISI 303 SS Bar

(M303B0.500x0.500)

Identify for D3257-1

Batch: M17625

SD

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank: 0.500" x 0.500" x 1.180" long Bar

SD 08/04/01

(6)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA420 and Dwg D3257

Deburr

ml/H.A 08/04/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml/H.A 08/04/04

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FITTING

Job Number: 38192

Part Number: D32571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

-Location: _____

5780

08/4/7

(6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-07

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

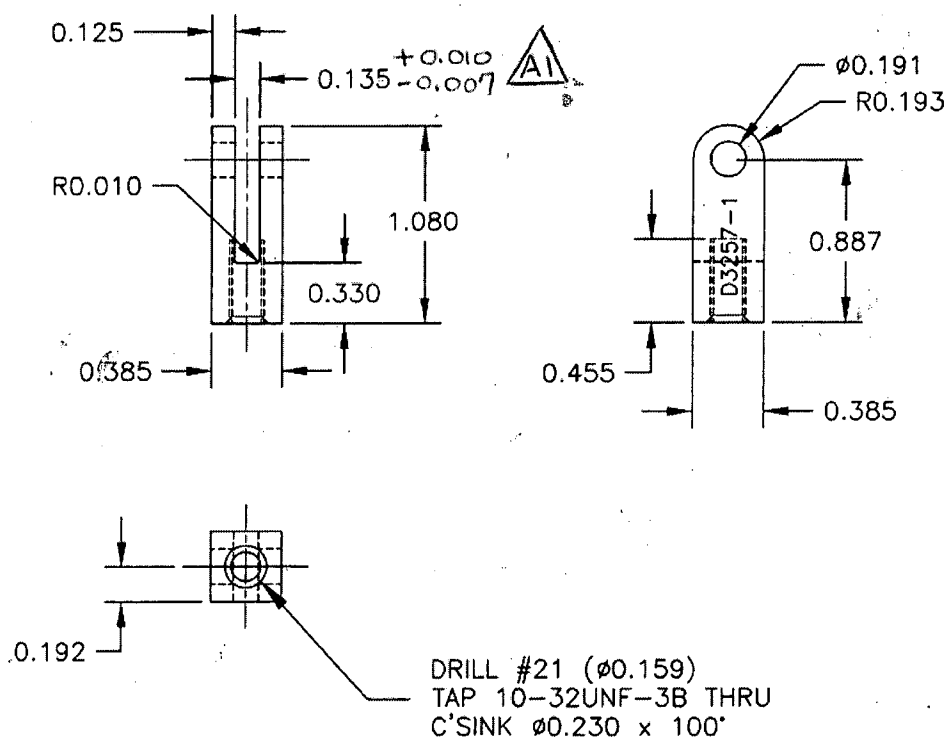
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	04.12.14	ADD TOLERANCE	

RELEASED
04.04.05



D3257-1 FITTING

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38192

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